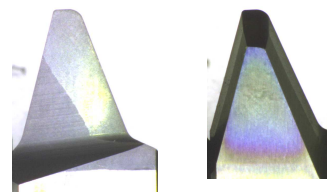
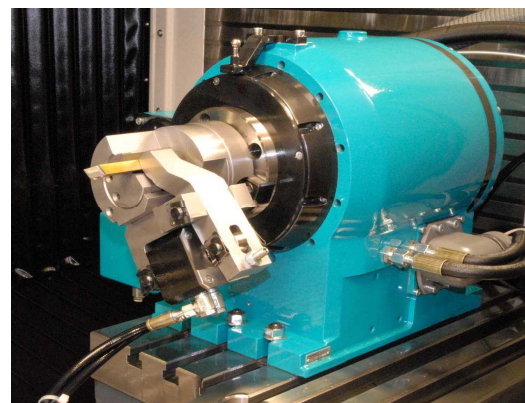













Gear Blade Oerlikon BxH 10.16 x 12.7

A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face. When inverting the operation on one of the sides, the complete profile can be preground with one side of the profile, preserving the opposite corner for finishing.



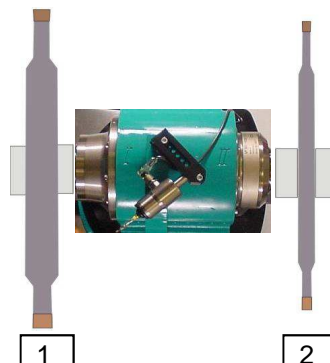
1. Cycletime for Resharpener

Workpiece:	RH inner blade Spir; 10.16 x 12.7 x 115 mm					
Material	CARBIDE					
Operations						
Feed [mm/Min]	2000	80	80	85	85	80
Power [kW]		2.1	2.1	0.9	0.9	0.9
Cutting feed [m/s]		19	19	22	22	20
Used wheels						
Grinding time [s]	18	42	42	43	28	32
Total cycle time	3 Min 25					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø250 D181
2	14A1 Ø250 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 31i B5 Software: Quinto 5
Accessories:

Responsible engineer: 31.10.2014, ADA

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China

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